

Work Order ID 82006

\*82006\*

Page 1

March-21-12 3:43:28 PM

Item ID: D350-636-012

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Skidtube RH

Start Date: 21/03/2012 Start Qty: 1.00

\*1\*

Cust Item ID:

Required Date: 04/04/2012 Req'd Qty: 1.00

\*1\*

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/03/21

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2750

F

D3492

C

100

0.00

\*100\*

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy blue file and type labels per PPP D350-636-012 CHG 006

MLJ 12-4-16

Sizkyk

B82006 RH

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 82006****\*82006\***

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March-21-12 3:43:28 PM

Item ID: D350-636-012

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\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Skidtube RH

Start Date: 21/03/2012 Start Qty: 1.00

\*1\*

Cust Item ID:

Required Date: 04/04/2012 Req'd Qty: 1.00

\*1\*

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

110

0.00

**\*110\***

Skidtubes

Skidtubes

Skidtubes

**Memo**

0.00

1- Pick D2600-3 Bent

2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside AFT end per dwg D2750

3- Drill pilot holes for blade fitting bolt holes using DT8983. Open to 0.500", deburr.

4- Locate DT8329 off of blade fitting bolt holes and drill pilot holes for blade fitting

5- Drill only two fwd step holes using DT9616. Ensure proper positioning.

6- Drill pilot holes as per Dwg D2750 sheet 4 (D2750-2 details). Drill using drill Jig DT8150 &amp; DT8863A for first side only DT8863B for second side (detail K)

7- Clecko DT8863B on second side of tube and drill pilot holes for detail B.  
\*\*\*SECOND SIDE\*\*\*

8-Open up holes for Detail "K" to 0.375" (4 holes per side) and blade fitting location holes to 0.500" (total of 4 holes per side) as per dwg D2750. Open up holes for ground handling and detail L to 0.500" (8 holes per side)

9-Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to 0.297".

10-Open up holes of Detail A to 0.297" (total of 2 holes per side)

PTO  
12-03-22  
12/04/02

# Dart Aerospace Ltd

W/O: 82006		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D350-636-012 PAR #:          Fault Category: Skid tube NCR: Yes No DQA: Not Date: 12/09/23  
 12-1368 Resolution: Scrap Disposition: Scrap QA: N/C Closed: OK Date: 12/4/23

NCR:		WORK ORDER NON-CONFORMANCE (NCR) 108.56						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12-3-22	110	holes at detail H do not line up from one side to the other holes are off by 0.074" RC; New employee, Training + lack of experience.	JP 12.03.22 PSOK	Scrap tube + Replace D2600-3-Bent BA# 82347	PS 12-4-2	S 12/4/23	JP 12.03.22 PS1042	S 12/4/23

NOTE: Date & initial all entries

# Work Order ID 82006

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March-21-12 3:43:28 PM

Item ID: D350-636-012

Accept

\*N9000040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Skidtube RH

Start Date: 21/03/2012 Start Qty: 1.00

\*1\*

Cust Item ID:

Required Date: 04/04/2012 Req'd Qty: 1.00

\*1\*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

11-Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left/  
from bending as per QSI 004

A/R Aluminum Rod batch: *m120164 BE 12/04/02*

12-Grind welds flush as per Dwg D2750 *CF 12.4-3*

120

QC10- Inspect visual per QSI004- ground welds

0.00

\*120\*

QC

Memo

0.00

Quality Control

130

QC5- Inspect part completeness to step on W/O

0.00

\*130\*

QC

Memo

0.00

Quality Control

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

**Work Order ID 82006****\*82006\***

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Item ID: D350-636-012

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**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Skidtube RH

Start Date: 21/03/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 04/04/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

140

Chemical Conversion Coat per QSI005 4.1

0.00

**\*140\***

HandFinish

Memo

0.00

Hand Finishing

7/6 12-4-3

150

QC7-Inspect Chemical Conversion Coat

0.00

**\*150\***

QC

Memo

0.00

Quality Control

SAD 10-04-03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



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\*N9000040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Skidtube RH

Start Date: 21/03/2012 Start Qty: 1.00

\*1\*

Cust Item ID:

Required Date: 04/04/2012 Req'd Qty: 1.00

\*1\*

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:  
QC: Date: SPC (Y/N): Date:

Run Start \*NR1\*  
Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Skidtubes	0.00							
*160*									
Skidtubes	<b>Memo</b>	0.00							
Skidtubes	1-Open up holes of Detail L and ground handling to 0.625" (total of 8 holes per side) as per dwg D2750.								
	2-Open up holes of Detail K to 0.750" (total of 4 holes per side) as per dwg D2750.								
	3-Open float holes to .500" (4 per Side)								
	4-Chamfer holes of Detail K, L, ground handling and float holes per dwg D2750 (welding instructions on sheet 9)								
	5-Deburr and blow out all chips from inside of tube								
	6-Prepare tube for welding, remove alodine as required.								
	7-Bond web D2739 in place as per QSI 015								
	A/R Sikaflex-291 batch: <u>M 120513</u> exp. date: <u>12-8-13</u>								
	8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004 (welding instructions on sheet 9)								
	A/R Aluminum Rod batch: <u>M 120164</u>								
	9- At section AP-AP drill out x-bolt spacer to 0.404"								
	10-Grind welds flush as per Dwg D2750								
	11-Spot face ground handling holes section (total of 4 places per side) as per								

*Handwritten notes and stamps:*

12/04/03

12-04-04

12/04/03

12/4/9

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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**NOTE:** Date & initial all entries

**Work Order ID 82006****\*82006\***

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Item ID: D350-636-012

Accept

**\*N9000040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Skidtube RH

Start Date: 21/03/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 04/04/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

dwg D2750

12-Deburr holes

*B/CC 12/4/9*

170

QC10- Inspect visual per QSI004- ground welds

0.00

*S.7/4/9***\*170\***

QC

Memo

0.00

Quality Control

180

QC5- Inspect part completeness to step on W/O

0.00

*S.7/4/9***\*180\***

QC

Memo

0.00

Quality Control

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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March-21-12 3:43:28 PM

Item ID: D350-636-012

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\*N9000040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Skidtube RH

Start Date: 21/03/2012 Start Qty: 1.00 \*1\*

Cust Item ID:

Required Date: 04/04/2012 Req'd Qty: 1.00 \*1\*

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 *190* HandFinish Hand Finishing	Pressure Wash per QSI005 4.3  Memo Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.	0.00  0.00				1X	Ø		M-L 12/04/11
200 *200* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum  Memo START TIME: 9:00 OVEN TEMPERATURE: 320 °F FINISH TIME: 9:30	0.00  0.00				1X	Ø		M-L 12/04/11
210 *210* QC Quality Control	QC3- Inspect Part Finish  Memo Inspect for foreign object per QSI 024	0.00  0.00				1RH	Ø		M-L 12/04/12

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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March-21-12 3:43:28 PM

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\*N9000040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Skidtube RH

Start Date: 21/03/2012 Start Qty: 1.00 \*1\*

Cust Item ID:

Required Date: 04/04/2012 Req'd Qty: 1.00 \*1\*

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start \*NR1\*

QC: Date: SPC (Y/N): Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
230		0.00							
*230*	HandFinishing					124	1	11	12/04/12
HandFinish		0.00							
Hand Finishing	<div><div>Memo</div><div>1-Install inserts as per dwg D2750</div><div>2-Inspect for Foreign Objects</div><div>3-Spray inside of tube with "LPS-3"</div><div>batch: NIA</div><div>4-Install blade fitting D3488-042, wearshoes and ground handling hardware as per dwg D2750</div><div>SIKA FLEX 241</div><div>BATCH: M120318</div><div>EXP DATE: 12/02</div><div>5-assemble o'ring to plug as per dwg D3492 and apply o'ring lube</div><div>A/R 55-o'ring lube batch: 1440340</div><div>6-Coat all exposed fasteners with "LPS Procyon"</div><div>batch: M14586</div></div>								

12/11 12/04/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Work Order ID 82006

**\*82006\***

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March-21-12 3:43:28 PM

Item ID: D350-636-012 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Skidtube RH  
 Start Date: 21/03/2012 Start Qty: 1.00 **\*1\*** Cust Item ID:  
 Required Date: 04/04/2012 Req'd Qty: 1.00 **\*1\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
240	QC5- Inspect part completeness to step on W/O	0.00							
<b>*240*</b>		0.00							
QC	Memo								
Quality Control									
250	Pick Kit	0.00							
<b>*250*</b>		0.00							
Packaging	Memo								
Packaging									
260	QC4- 100% Inspect kits for completeness	0.00							
<b>*260*</b>		0.00							
QC	Memo								
Quality Control									

*8/2/12/17*

*4/2/12/17*

*8/2/12/17*

*(XU)*

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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**Work Order ID 82006****\*82006\***

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March-21-12 3:43:28 PM

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**\*N9000040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Skidtube RH

Start Date: 21/03/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 04/04/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

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Date:

Run Start **\*NR1\***

QC:

Date:

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Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

270

0.00

**\*270\***

Packaging

Packaging

Memo

0.00

Packaging

Package as per PPP D350-636-012

72

Rev I

280

0.00

**\*280\***

QC21- Final Inspection - Work Order Release

QC

Memo

0.00

Quality Control

1x

12-04-17

12/4/19

12-04-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

March-21-12 3:43:33 PM

Page 1

Work Order ID: 82006

\*82006\*

Parent Item: D350-636-012

\*D350-636-012\*

Parent Item Name: Skidtube RH

Start Date: 21/03/2012

Required Date: 04/04/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:102.09.25Rearranged procedure stepsKJ  
 IPP Rev:J 06-03-29 As per Rev D EC  
 IPP Rev:K 06-07.13 As per dsi9343 EC  
 IPP Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By:EC  
 IPP Rev:M 08-04-22 update steps 4,13 DD verified by:EC  
 IPP Rev:N 08-09-23 revF as per dwg DD verified by:ec IPP Rev:O  
 10.06.22 revise seq110 DD verf:EC IPP Rev:P 10.10.01 as  
 per IIN revH DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2600-3-BENT

Manufactured

No

110

Each

17.0000

1

1

1

7/20/02

\*D2600-3-BENT\*

Extrusion Bent

Location

Loc Qty

Loc Code

LG

17

66875

7

73253

1

75021

1

75022

1

75023

1

81330

6

D2744

Manufactured

No

110

Each

56.0000

1

1

\*D2744\*

Cap

Location

Loc Qty

Loc Code

LG002

56

62715

1

70881

9

71861

4

78900

42

\*\*

BE 12/04/02

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 82006

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

\*82006\*

\*D350-636-012\*

Start Date: 21/03/2012

Required Date: 04/04/2012

Start Qty: 1.00

Required Qty: 1.00

D2739

Manufactured No

160

Each

3.0000

1

1

\*D2739\*

350 1 Beam

\*\*

Location

LG

72155

80083

Loc Qty

3

1

2

Loc Code

1

7/5 12.4.3

D2743

Manufactured No

160

Each

216.0000

8

8

\*D2743\*

Crossbolt Spacer

\*\*

Location

LG001

67766

68251

73403

74445

78603

79517

Loc Qty

216

4

3

64

1

44

100

Loc Code

8

BE 12/04/04

D3490-3

Manufactured No

160

Each

22.0000

4

4

\*D3490-3\*

Cross Bolt Spacer

\*\*

Location

LG001

78800

Loc Qty

22

22

Loc Code

BE 12/04/04  
B 82016 #4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

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Work Order ID: 82006

\*82006\*

Parent Item: D350-636-012

\*D350-636-012\*

Parent Item Name: Skidtube RH

Start Date: 21/03/2012

Required Date: 04/04/2012

Start Qty: 1.00

Required Qty: 1.00

D3490-1

Manufactured No

160

Each

33.0000

4

4

\*D3490-1\*

Cross Bolt Spacer

\*\*

BE 12/04/04  
BB1976 x4

Location

Loc Qty

Loc Code

LG001

33

62450

2

74875

4

77042

3

78793

24

D3631-1

Manufactured No

230

Each

191.0000

8

8

\*D3631-1\*

Washer

\*\*

sl 12/04/12

Location

Loc Qty

Loc Code

ST072

191

68062

2

75548

189

D3791-1

Manufactured No

230

Each

15.0000

1

1

\*D3791-1\*

Wearplate

\*\*

sl 12/04/12

Location

Loc Qty

Loc Code

FP002

15

62239

2

75041

1

78897

12

V1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Work Order ID: 82006

\*82006\*

Parent Item: D350-636-012

\*D350-636-012\*

Parent Item Name: Skidtube RH

Start Date: 21/03/2012

Required Date: 04/04/2012

Start Qty: 1.00

Required Qty: 1.00

D3793-3

Manufactured No

230

Each

24.0000

1

1

\*D3793-3\*

Wearshoe

\*\*

M 12/04/12

## Location

## Loc Qty

## Loc Code

FP001

12

80434

12

FP002

12

78935

12

X1

MS21043-6

Purchased

No

230

Each

797.0000

4

4

\*MS21043-6\*

NUT

\*\*

M 12/04/12

## Location

## Loc Qty

## Loc Code

FG

20

103693

20

ST301

777

112314

71

117887

6

118384

200

120308

500

X4

D3794-1

Manufactured

No

230

Each

22.0000

1

1

\*D3794-1\*

Gasket

\*\*

M 12/04/12

## Location

## Loc Qty

## Loc Code

FP002

22

75042

10

80435

12

X1

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Work Order ID: 82006

\*82006\*

Parent Item: D350-636-012

\*D350-636-012\*

Parent Item Name: Skidtube RH

Start Date: 21/03/2012

Required Date: 04/04/2012

Start Qty: 1.00

Required Qty: 1.00

NAS1611-010

Purchased

No

230

Each

185.0000

8

8

\*NAS1611-010\*

O-RING

\*\*

261 12/04/12

Location

Loc Qty

Loc Code

FP

50

110915

0

120770

50

FP001

135

110915

14

117460

8

118077

1

118612

3

119438

47

120308

12

120986

50

X96

D2741

Manufactured

No

250

Each

33.0000

1

1

\*D2741\*

Blade, 350 Skidtube

\*\*

12/4/12

Location

Loc Qty

Loc Code

ST

-10

ST466

43

71856

1

76984

32

76984

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Work Order ID: 82006

**\*82006\***

Parent Item: D350-636-012

**\*D350-636-012\***

Parent Item Name: Skidtube RH

Start Date: 21/03/2012

Required Date: 04/04/2012

Start Qty: 1.00

Required Qty: 1.00

NAS1515H3L

Purchased

No

230

Each

172.0000

4

4

**\*NAS1515H3I \***

WASHER

\*\*

xl 12/04/12

Location

Loc Qty

Loc Code

FG

40

102472

40

ST277

132

118686

3

119438

1

120072

32

120360

96

xl

NAS1611-013

Purchased

No

230

Each

144.0000

8

8

**\*NAS1611-013\***

O-RING

\*\*

11/12/16 (xg) xl 11/09/12

Location

Loc Qty

Loc Code

FP001

144

116582

5

117291

2

117887

53

119623

36

120910

48

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



## Picklist Print

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Work Order ID: 82006

\*82006\*

Parent Item: D350-636-012

\*D350-636-012\*

Parent Item Name: Skidtube RH

Start Date: 21/03/2012

Required Date: 04/04/2012

Start Qty: 1.00

Required Qty: 1.00

AN3C6A

Purchased

No

230

Each

571.0000

4

4

\*AN3C6A\*

\*\*

BOLT

LocationLoc QtyLoc Code

FP001

1

111982

1

ST351

570

111982

2

116419

23

116549

2

116704

12

117619

10

117688

1

117872

5

118422

13

119449

21

120423

81

120693

400

NAS1149C0832R

Purchased

No

230

Each

301.0000

1

1

\*NAS1149C0832R\*

\*\*

WASHER

LocationLoc QtyLoc Code

ST297

301

114915

301

D3536-25

Manufactured

No

230

Each

14.0000

1

1

\*D3536-25\*

\*\*

Gasket

LocationLoc QtyLoc Code

FP002

14

78902

14

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# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

## Picklist Print

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Work Order ID: 82006

**\*82006\***

Parent Item: D350-636-012

**\*D350-636-012\***

Parent Item Name: Skidtube RH

Start Date: 21/03/2012

Required Date: 04/04/2012

Start Qty: 1.00

Required Qty: 1.00

D3794-3

Manufactured No

230

Each

29.0000

1

1

**\*D3794-3\***

\*\*

Gasket

LocationLoc QtyLoc Code

FP002

29

74530

2

78895

3

80436

24

AN3C5A

Purchased

No

230

Each

1,338.000

34

34

**\*AN3C5A\***

\*\*

Bolt

LocationLoc QtyLoc Code

FP001

7

115835

7

ST350

1331

116419

28

117343

13

117764

7

117872

2

119749

23

120423

758

1210168

500

D3537-1

Manufactured No

230

Each

87.0000

3

3

**\*D3537-1\***

\*\*

Wearpad

LocationLoc QtyLoc Code

FP001

82

79833

28

79835

54

FP002

5

69817

5

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# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Work Order ID: 82006

\*82006\*

Parent Item: D350-636-012

\*D350-636-012\*

Parent Item Name: Skidtube RH

Start Date: 21/03/2012

Required Date: 04/04/2012

Start Qty: 1.00

Required Qty: 1.00

D3535-25

Manufactured No

230

Each

17.0000

1

1

\*D3535-25\*

Wearshoe

\*\*

HL 12/04/12

## Location

## Loc Qty

## Loc Code

FP001

14

62233

1

80331

13

FP002

3

77617

3

D3492-3

Manufactured No

230

Each

45.0000

8

8

\*D3492-3\*

Plug

\*\*

B81963 cxg) HL 12/04/12

## Location

## Loc Qty

## Loc Code

FP-A

45

78600

45

AN960C10L

NAS1149C0332  
R

Purchased

No

230

Each

0.0000

38

38

\*AN960C10L \*

washer

\*\*

M121255 (x38) HL 12/04/12

D3488-042

Manufactured No

230

Each

18.0000

1

1

\*D3488-042\*

Blade Fitting Assembly, RH

\*\*

HL 12/04/12

## Location

## Loc Qty

## Loc Code

FP002

18

62003

1

75068

9

77015

8

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# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Work Order ID: 82006

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

\*82006\*

\*D350-636-012\*

Start Date: 21/03/2012

Required Date: 04/04/2012

Start Qty: 1.00

Required Qty: 1.00

ALS4-1032-225

Purchased

No

230

Each

980.0000

38

38

\*AI S4-1032-225\*

Insert

\*\*

u 11/04/12

## Location

## Loc Qty

## Loc Code

ST281

947

108696

146

110768

62

118386

55

118966

68

120671

616

ST282

33

120410

20

120451

13

x38

D3492-1

Manufactured

No

230

Each

106.0000

8

8

\*D3492-1\*

Plug

\*\*

1381963 u 11/04/12

## Location

## Loc Qty

## Loc Code

FP002

106

69531

8

74444

2

76235

4

77037

92

D3793-1

Manufactured

No

230

Each

16.0000

1

1

\*D3793-1\*

Wearshoe

\*\*

u 12/04/12

## Location

## Loc Qty

## Loc Code

FP001

16

77029

4

78901

12

VI

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



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Work Order ID: 82006

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

**\*82006\*****\*D350-636-012\***

Start Date: 21/03/2012

Required Date: 04/04/2012

Start Qty: 1.00

Required Qty: 1.00

AN8C35A

Purchased

No

230

Each

62.0000

1

1

**\*AN8C35A\***

BOLT

**\*\***

JL 12/04/12

LocationLoc QtyLoc Code

FP002

61

115960

1

117834

8

118286

52

ST346

1

114442

0

115188

0

115960

1

MS21083C8

Purchased

No

230

Each

79.0000

1

1

**\*MS21083C8\***

NUT

**\*\***

JL 12/04/12

LocationLoc QtyLoc Code

FP002

1

115884

1

ST303

12

115884

0

118077

1

119309

2

119436

7

119638

2

ST304

66

120142

16

120731

25

121011

25

VI

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

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Work Order ID: 82006

\*82006\*

Parent Item: D350-636-012

\*D350-636-012\*

Parent Item Name: Skidtube RH

Start Date: 21/03/2012

Required Date: 04/04/2012

Start Qty: 1.00

Required Qty: 1.00

D2745

Manufactured No

230 Each

112.0000 8 8

\*D2745\*

Bushing

\*\*

del 21/03/12

Location

Loc Qty

Loc Code

FP

100

79518

100

x8

FP001

12

69529

1

76142

1

78597

10

AN6C44A

Purchased No

230 Each

95.0000 4 4

\*AN6C44A\*

BOLT

\*\*

del 21/03/12

Location

Loc Qty

Loc Code

FG

2

103964

2

ST343

93

120143

25

120465

27

120641

21

121013

20

x4

D3532-1

Manufactured No

250 Each

39.0000 2 2

\*D3532-1\*

Spacer

\*\*

del 21/03/12

Location

Loc Qty

Loc Code

ST053

39

78839

39

78839

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Work Order ID: 82006

\*82006\*

Parent Item: D350-636-012

\*D350-636-012\*

Parent Item Name: Skidtube RH

Start Date: 21/03/2012

Required Date: 04/04/2012

Start Qty: 1.00

Required Qty: 1.00

MS21083C8

Purchased

No

250

Each

79.0000

2

2

\*MS21083C8\*

NUT

\*\*

## Location

## Loc Qty

## Loc Code

FP002

1

115884

1

ST303

12

115884

0

118077

1

119309

2

119436

7

119638

2

ST304

66

120142

16

120731

25

121011

25

120731

NAS1149D0863J

Purchased

No

250

Each

227.0000

2

2

\*NAS1149D0863J\*

WASHER

\*\*

## Location

## Loc Qty

## Loc Code

ST298

227

118078

36

119307

91

120308

100

119307

D3493-1

Manufactured

No

250

Each

62.0000

2

2

\*D3493-1\*

Washer

\*\*

## Location

## Loc Qty

## Loc Code

ST050

62

70697

2

77573

20

78835

40

78835

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# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Work Order ID: 82006

\*82006\*

Parent Item: D350-636-012

\*D350-636-012\*

Parent Item Name: Skidtube RH

Start Date: 21/03/2012

Required Date: 04/04/2012

Start Qty: 1.00

Required Qty: 1.00

AN8C21A

Purchased

No

250

Each

67.0000

2

2

\*\*

\*AN8C21A\*

BOLT

Location

Loc Qty

Loc Code

ST343

67

118758

5

120094

38

120872

4

121067

20

120094

12/4/12

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

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WORK ORDER

NO. 82006 MLJ

12/03/21

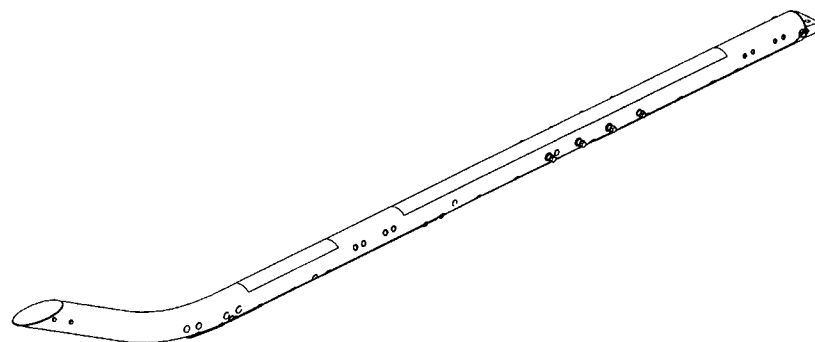
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GENERAL NOTES:

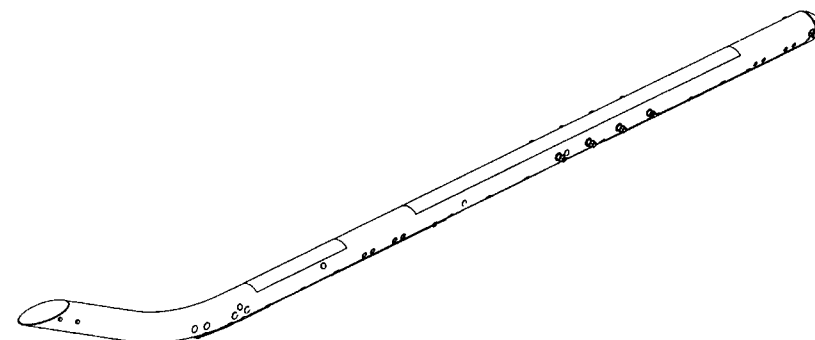
- 1) MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- 2) FINISH:  
ACID ETCH, ALONDE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.  
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- 8) WELD PER DART QSI 004
- 9) INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES ( $\phi 0.297$ ) FOR WEARSHOE INSERTS
- 10) FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:  
MINIMUM YIELD TENSILE STRENGTH = 35 KSI  
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- 11) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS.  
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY. CLEAN EXCESS OFF  
POWDER COATING WITH MEK DEGREASER.
- 12) SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- 13) SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

F	INCORPORATE DSI 9413. QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/3 REPLACES D3535-13/35 (ZN C8-1); D3794-1/3 REPLACES D3536-13/35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL) WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS; CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H8L; REMOVE D2741; QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN	RA	DART AEROSPACE USA, INC.	
DRAWN	RA	PORT HADLOCK, WA	
CHECKED	RA	DRAWING NO.	REV. F
MFG. APPR.	RA	D2750	SHEET 1 OF 11
APPROVED	RA	TITLE	SCALE
DE APPR.	RA	350 SKIDTUBE ASSEMBLY	NTS
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D2750-041 350 SKIDTUBE ASSEMBLY, LH

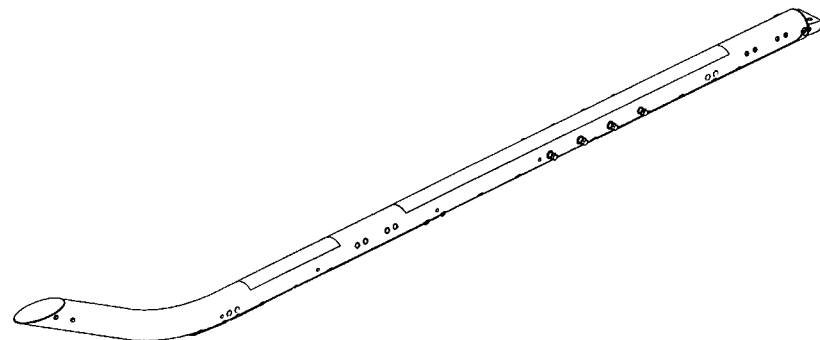


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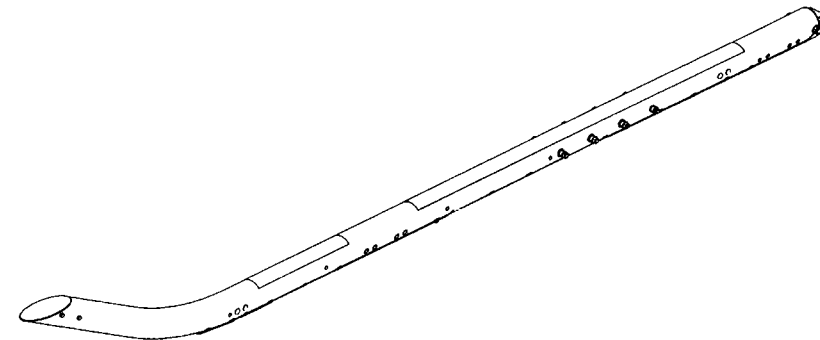
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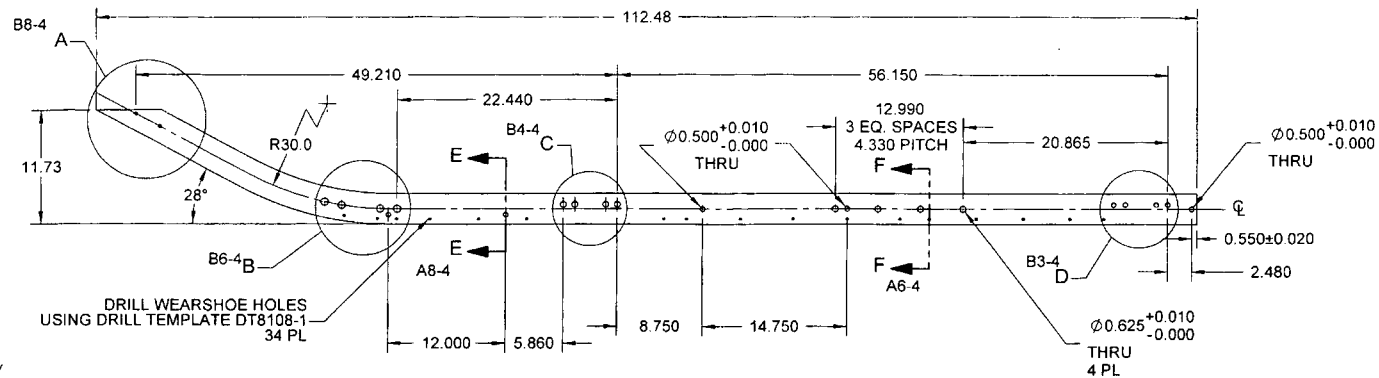
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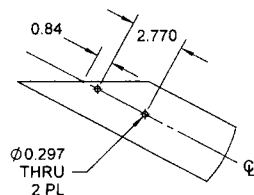
D2750-044 350 SKIDTUBE ASSEMBLY, RH

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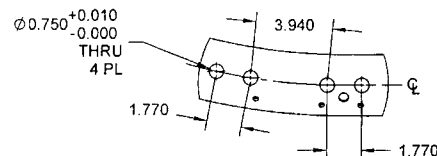
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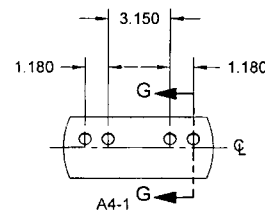
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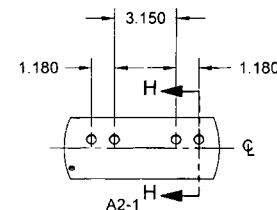
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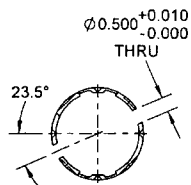
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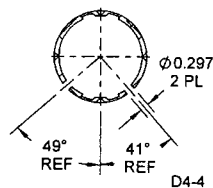
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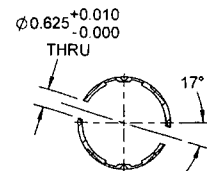
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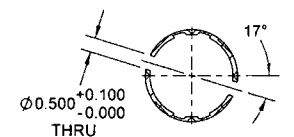
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SCALE 3X, 2 PL



**SECTION F-F**  
SCALE 3X, 17 PL



**SECTION G-G**  
SCALE 3X, 4 PL



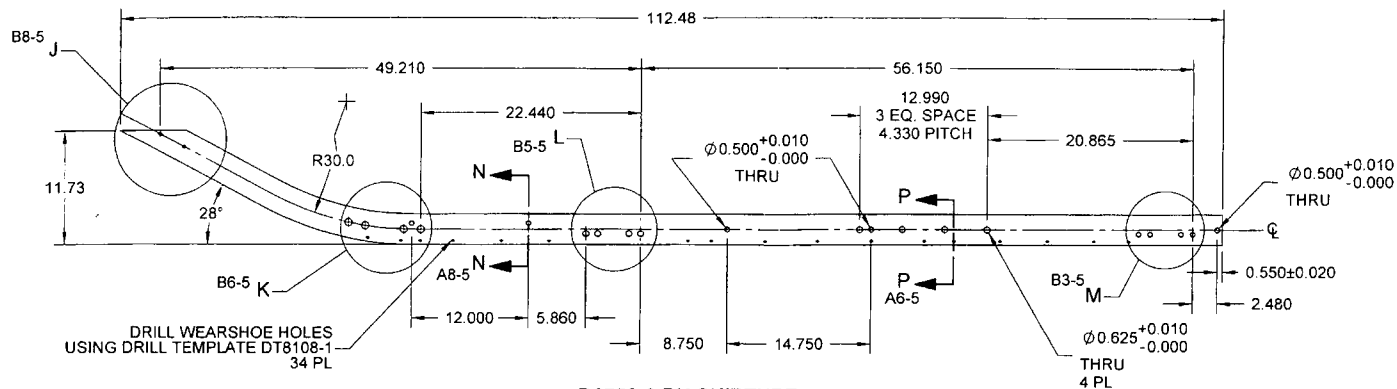
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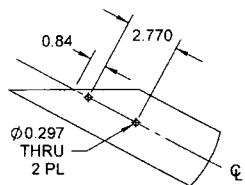
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DRAWING NO. <b>D2750</b>	REV. F SHEET 4 OF 11
TITLE <b>350 SKIDTUBE ASSEMBLY</b>	SCALE NTS
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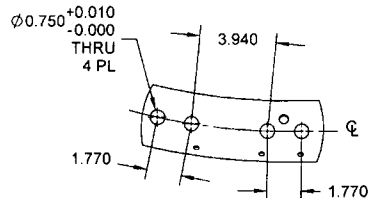
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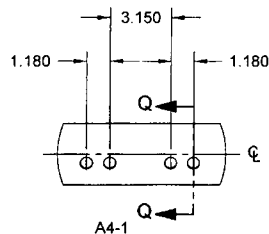
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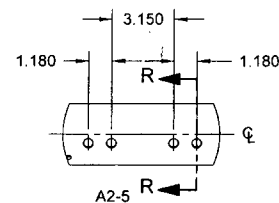
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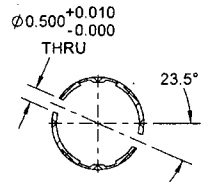
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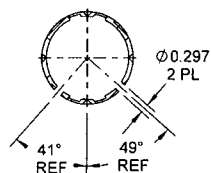
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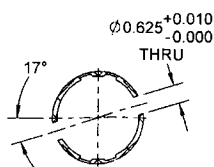
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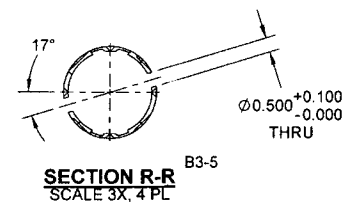
**SECTION N-N**  
SCALE 3X, 2 PL



**SECTION P-P**  
SCALE 3X, 17 PL



**SECTION Q-Q**  
SCALE 3X, 4 PL



**SECTION R-R**  
SCALE 3X, 4 PL

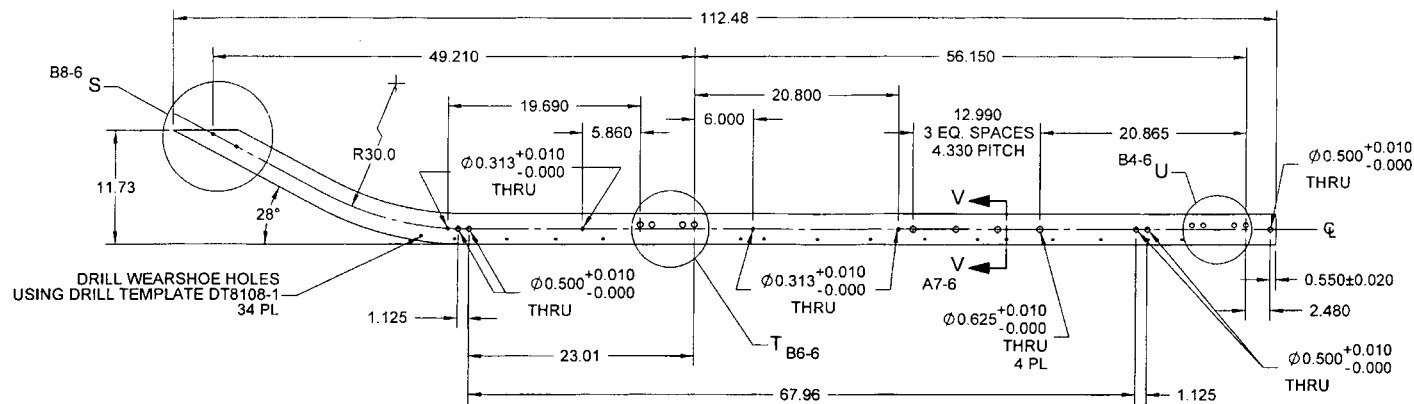
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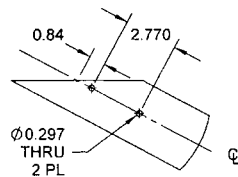
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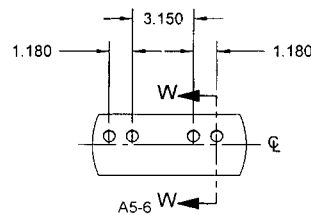
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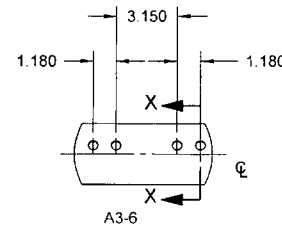
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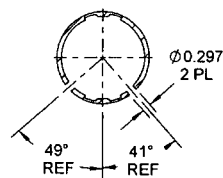
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D8-6



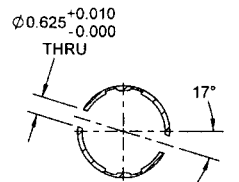
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C5-6



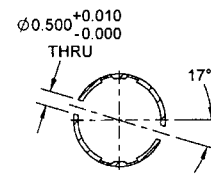
**DETAIL U**  
SCALE 2X  
D3-6



**SECTION V-V**  
SCALE 3X, 17 PL  
C4-6



**SECTION W-W**  
SCALE 3X, 4 PL  
B6-6



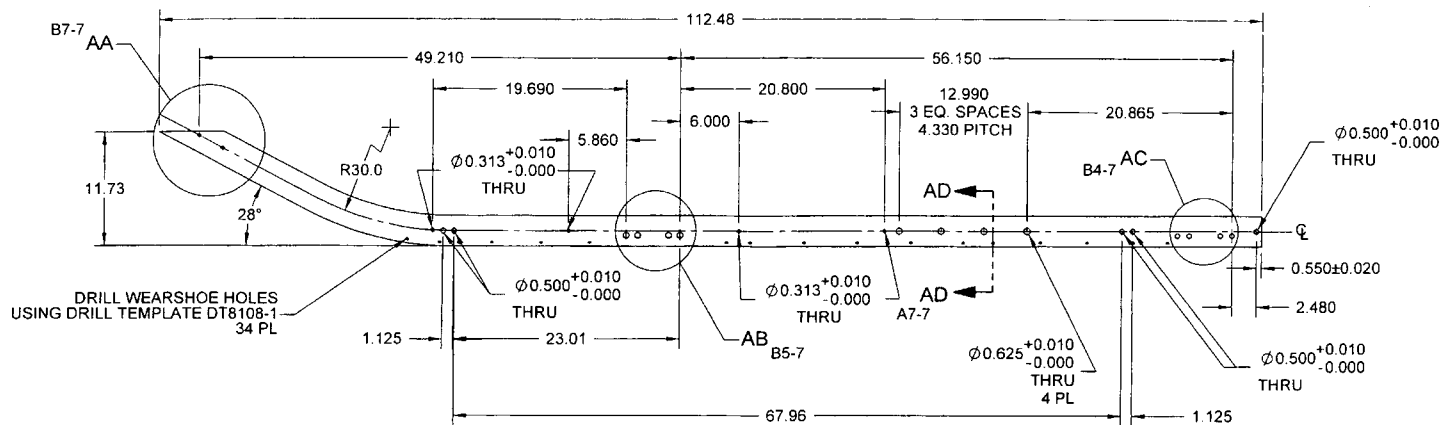
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B4-6

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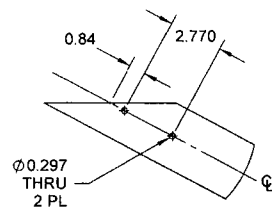
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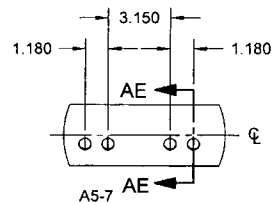
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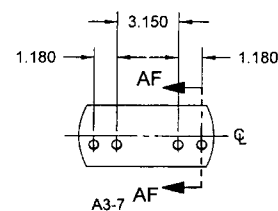
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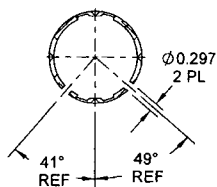
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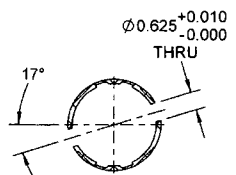
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C4-7  
SCALE 2X



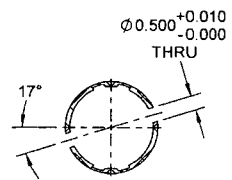
**DETAIL AC**  
D3-7  
SCALE 2X



**SECTION AD-AD**  
D3-7  
SCALE 3X, 17 PL



**SECTION AE-AE**  
B6-7  
SCALE 3X, 4 PL

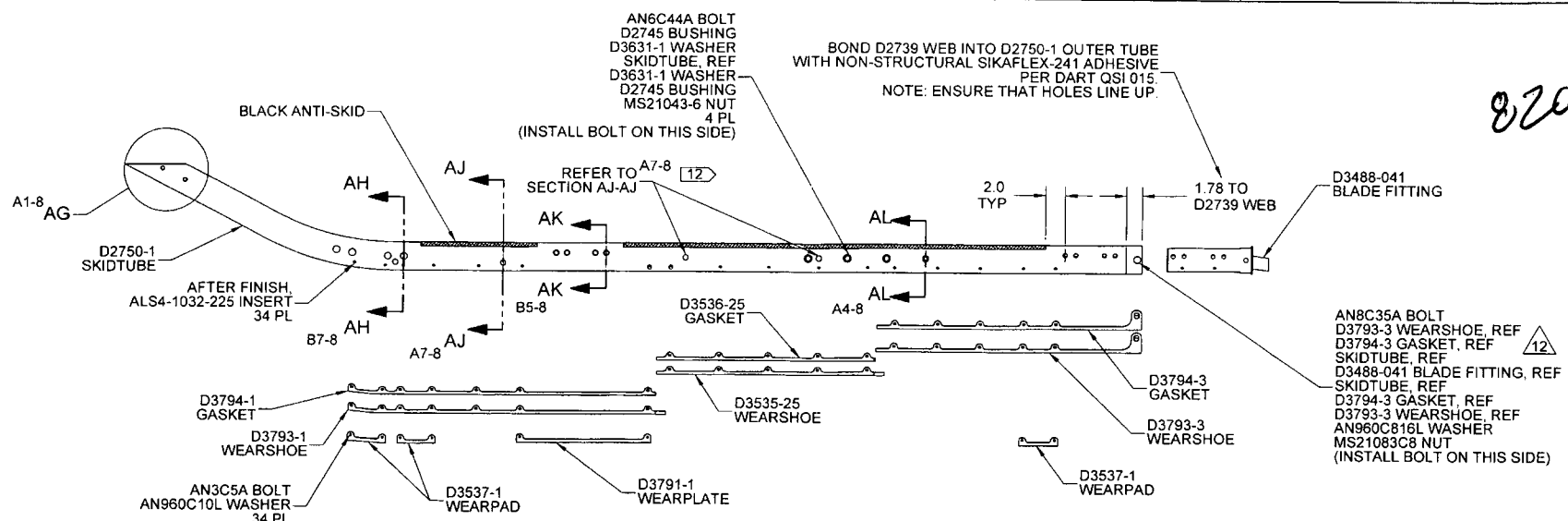


**SECTION AF-AF**  
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SCALE 3X, 4 PL

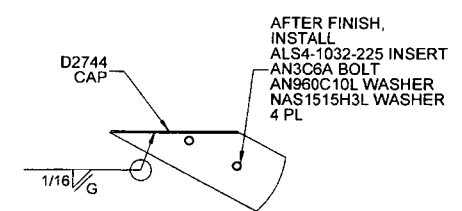
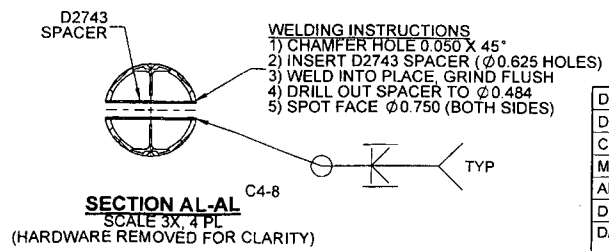
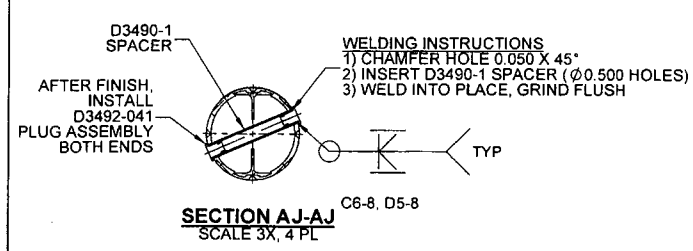
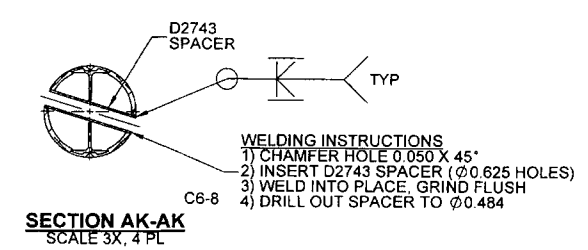
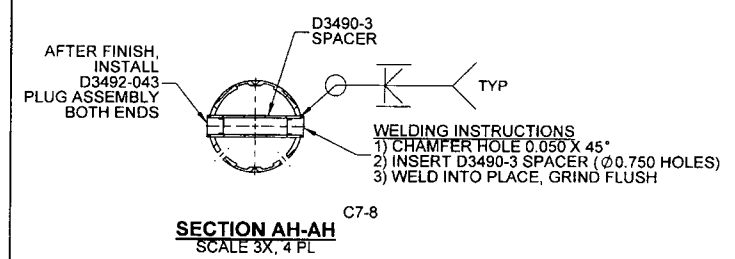
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**D2750-041 350 SKIDTUBE ASSEMBLY, LH**

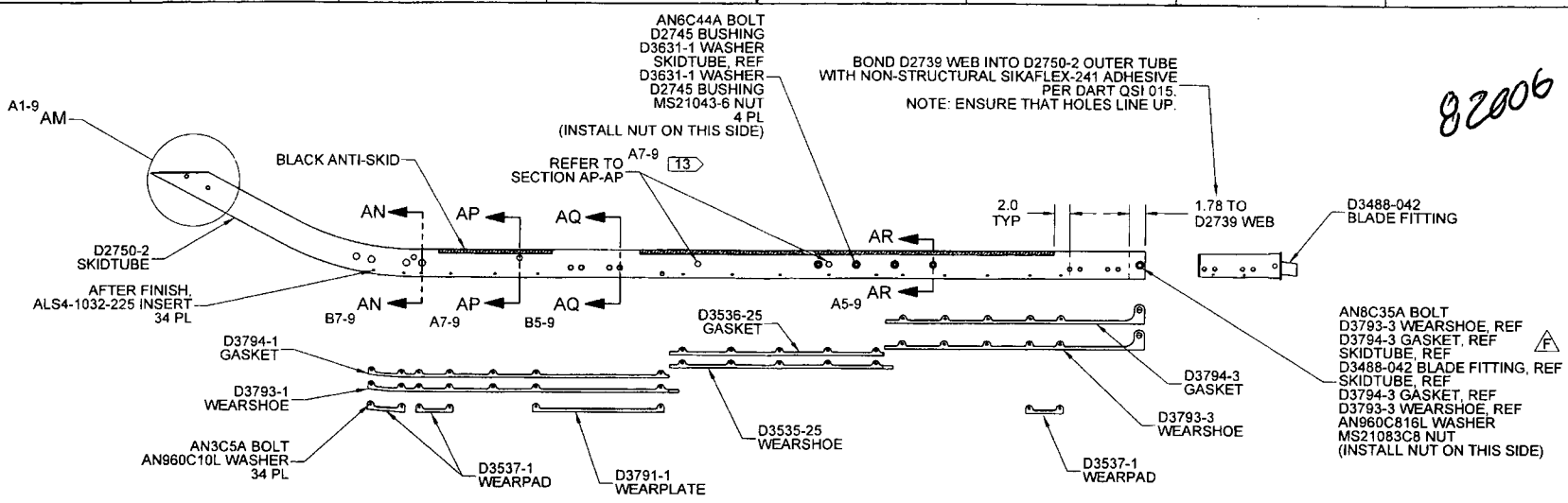


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DE APPR.	REV. F	SHEET 8 OF 11 SCALE NTS
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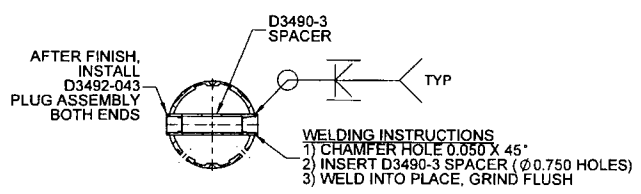


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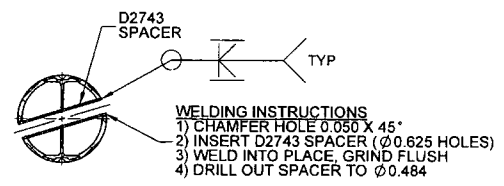
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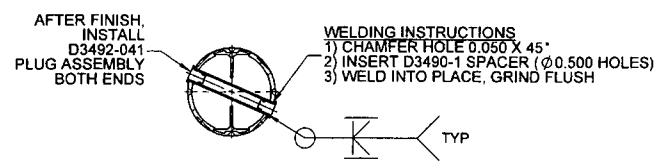
**D2750-042 350 SKIDTUBE ASSEMBLY, RH**



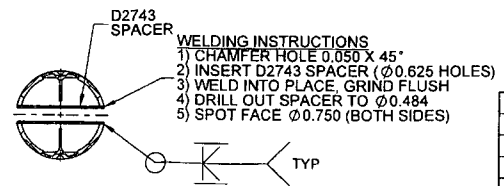
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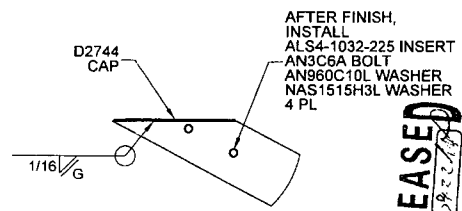
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**SECTION AP-AP**  
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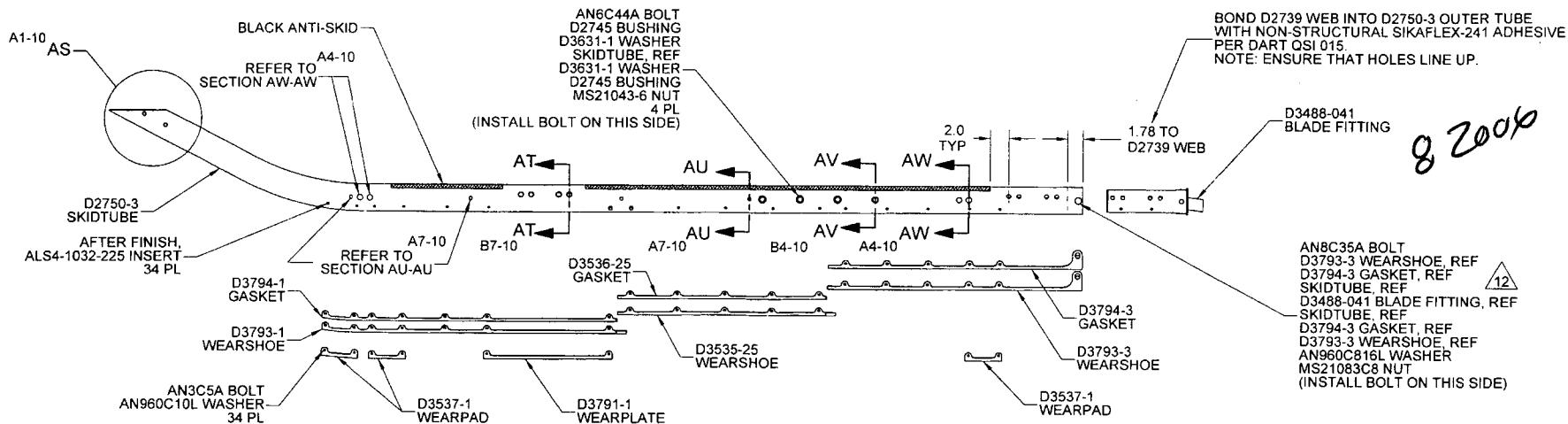
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(HARDWARE REMOVED FOR CLARITY)



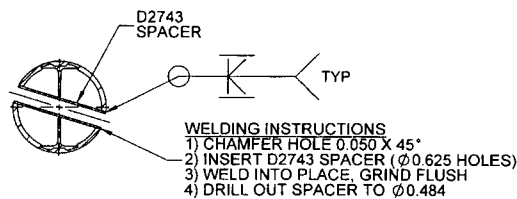
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SCALE 2X

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APPROVED		TITLE	SCALE
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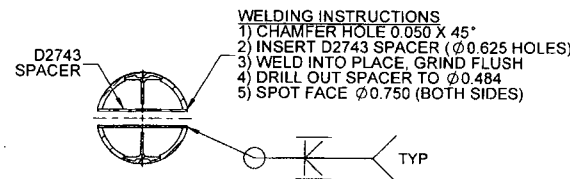
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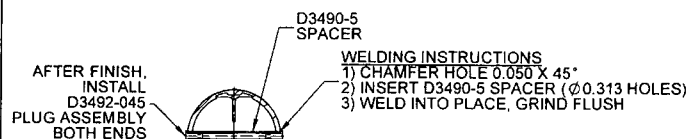
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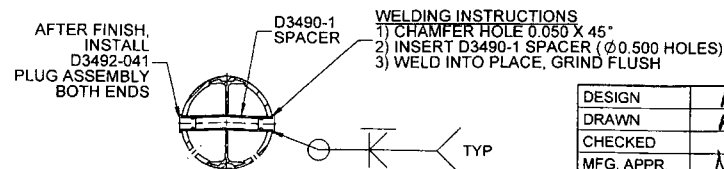
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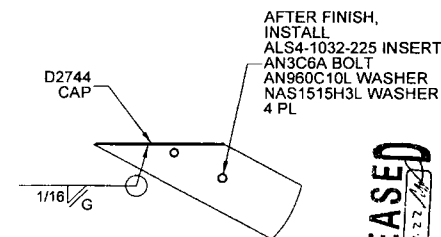
**SECTION AV-AV**  
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(HARDWARE REMOVED FOR CLARITY)



**SECTION AU-AU**  
SCALE 3X, 4 PL



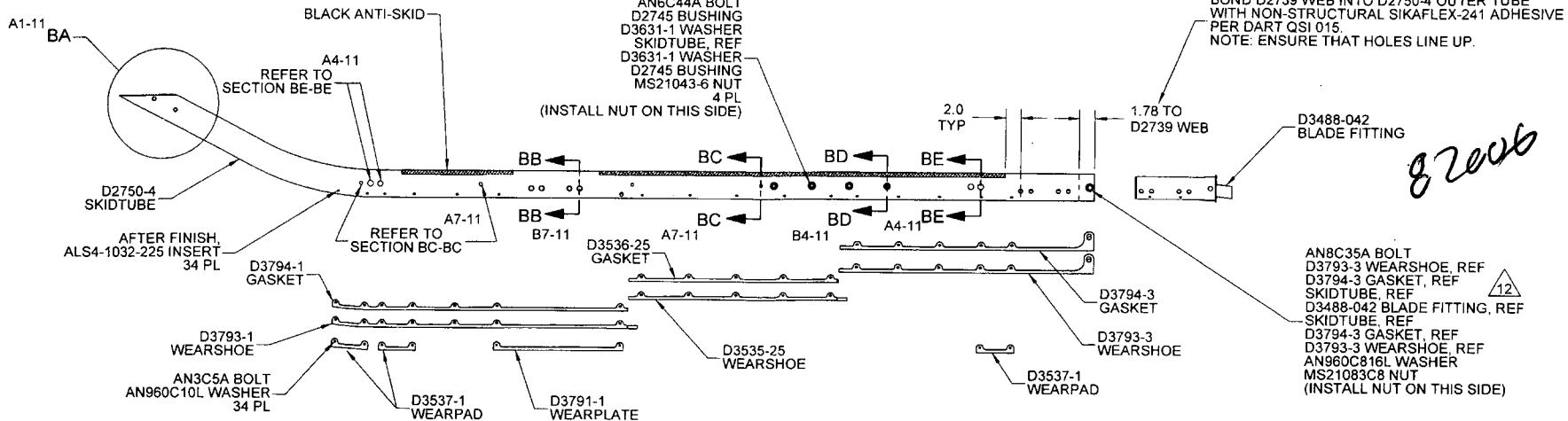
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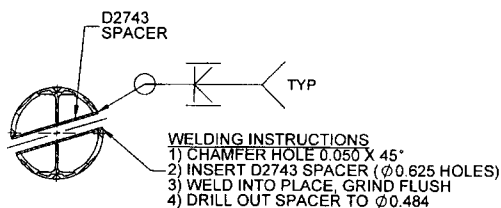
**DETAIL AS**  
SCALE 2X

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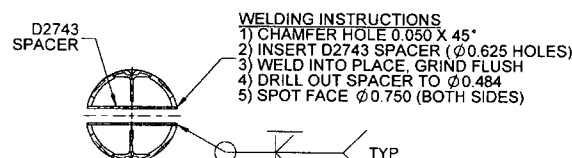
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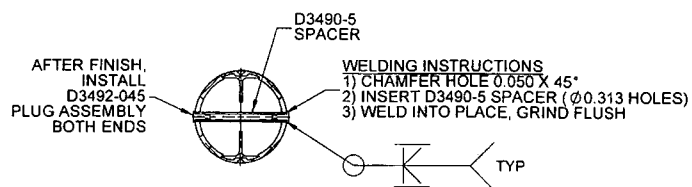
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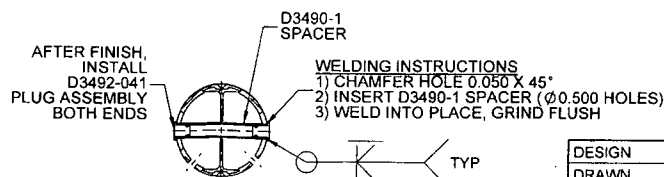
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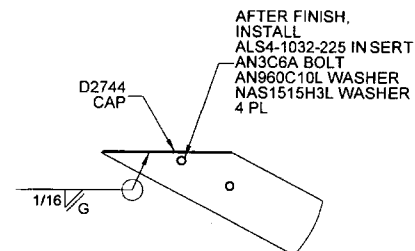
#### SECTION BD-BD SCALE 3X, 4 PL (HARDWARE REMOVED FOR CLARITY)



#### SECTION BC-BC SCALE 3X, 4 PL



#### SECTION BE-BE SCALE 3X, 4 PL



#### DETAIL BA SCALE 2X

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NO. 286

AWS D17.1.2001  
QUALIFICATION TEST RECORD

Name: Barclay Elliott  
Job number: 82189  
Part number: A350-606-012  
Description: Skid tube  
Welding Process: Tig[☒] Mig[ ]  
Base material: Alum.  
Current: AC[☒] DC[ ]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[ ]  
Penetration: pass[☒] fail[ ]

UNACCEPTABLE

Cracks: pass[☒] fail[ ]  
Undercut: pass[☒] fail[ ]  
Pin holes: pass[☒] fail[ ]  
Overlap (cold lap): pass[☒] fail[ ]  
Porosity (surface): pass[☒] fail[ ]  
Coloration: pass[☒] fail[ ]

Qualifier David Lued Date of Test Coupon 12.24.03  
Welder Barclay Elliott Date of Test Coupon 12-04-03

The above named individual is qualified in accordance with AWS D17.1.2001 to weld